

Work Order ID 67766

Wednesday, March 30, 2011 10:35:03 AM



Page 1

Item ID: D2743

Accept



Setup Start



Revision ID:

Stop



Item Name: Crossbolt Spacer

Start Date: 3/30/2011 Start Qty: 80.00

Required Date: 4/4/2011 Req'd Qty: 80.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-03-30 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2743

Rev B

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA202 & DWG D2743

FOLIO REV:

DWG REV:

2-DEBURR AS REQUIRED

11/4/15

169

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11/4/15

169

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Clean crossbolt spacer with ultra bright aluminum cleaner

160

Identify as per dwg & Stock Location: LG

0.00



Packaging

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL



11.4.6

169

169 0 BEA/04/07

169 0 BEA/04/07

W/O:		WORK ORDER CHANGES						
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Item Name: Crossbolt Spacer

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Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 80.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/74

N 11-04-7

169

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, March 30, 2011 10:35:09 AM

Page 1

Work Order ID: 67766



Parent Item: D2743

Parent Item Name: Crossbolt Spacer

Start Date: 3/30/2011

Required Date: 4/4/2011

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP ☐ E ☐ 05.04.13 ☐ Reformat; removed tumble and deburr step ☐ KJ/JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.625W.065		Purchased	No			100	f	48.0000	0.2667	22.45895			
6061-T6 RD Tube .625 x.065W													

Location

Loc Qty

Loc Code

MAT014

48

116720

48

Handwritten: 11/04/05
48 f

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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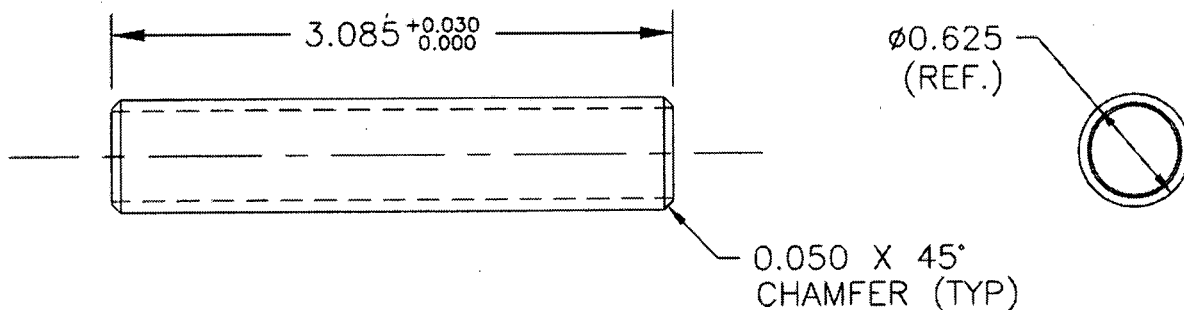


DESIGN <i>[Signature]</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>KE</i>	DRAWING NO. D2743	REV. B SHEET 1 OF 1
DATE 98.12.08		TITLE CROSS BOLT SPACER	SCALE 1:1
A	98.04.16	NEW ISSUE	
B	98.12.08	3.085 WAS 3.060	

RELEASED
98.12.16 DS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *6-7744*

PL 11-03-30



MATERIAL: 6061-T6 (WW-T-700/6) 0.625 DIA. X 0.065 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries